

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012456**Date Inspected:** 19-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use: Yes No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed: Yes No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up: Yes No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS: Yes No N/A
				Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Heavy Dock

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

South tower, lift 2 was suspended from the ZPMC 1600 ton floating crane while in position on top of south tower, lift 1. ZPMC workers were attaching bracing to the temporary staging around the lift1/lift 2 joint. This bracing was being used with jacking equipment to assist in aligning the two lifts and attaching the splice plates, some of which were in place with extra long bolts, but not drawn in tight against the tower skin. Also present and appearing to be monitoring the work was ZPMC QC Chen Tan, who was not a CWI.

Bay 11

No welding related work was observed being performed in Bay 11.

Bay 10

The only welding related work observed being performed in Bay 10 was as follows:

One ZPMC worker was gouging weld joint NSTL4-3B/L-1A located outside PCMK north tower, lift 4, skins C/D corner at 122.5M elevation. The area was well marked as an ultrasonic testing indication repair. The area of

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gouging had been preheated to an unknown temperature and a ZPMC preheating worker was present.

In addition to the above noted work in progress, this QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the root pass of the welds noted below. It was unknown to this QA Inspector if the welds were previously tested and accepted by ZPMC Quality Control personnel. This inspection was performed on an informational basis and no TL-6028 report was generated for this date. The member is identified as outside PCMK south tower, lift 5, skins A/B corner and skins B/C corner. The weld designations reviewed were SSD1-TL5-1B-F-9A, 37A at the A/B corner and SSD1-TL5-1B-F-11B, 38A at the B/C corner. No apparent indications were observed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
